

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027628**Date Inspected:** 14-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** Steve Jensen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** skyway**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

Skyway, Hinge "A"

This QA inspector observed the installation and welding of the 89 mm x 64 mm x9.5 mm angle identified as M1 to the plate identified as S1. The welding was performed by Jason Collins, ID-8128, utilizing the Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specification (WPS) ABF-WPS-D15-1160, Rev. 0. The WPS was also used by the QC inspector, Steve Jensen, to monitor the welding, the associated welding tasks and the QC weld inspection. The Welding was performed in the flat (1G) position with the work placed in an approximately horizontal plane and the weld metal deposited from the upper side. The welding and the QC weld inspection was observed and verified by this QAI at random intervals during this shift which appeared to comply documents. The welding was not completed during this shift.

QA Summary

This QA inspector observed the QC activities and the welding performed, as per the submittal identified as SUB-ABF-002549R03, "CCO 193" utilizing the WPS as noted above, which appeared to be posted at the weld station. The welding parameters and surface temperatures were verified by the QC inspectors utilizing a Fluke 337 clamp meter for the electrical welding parameters and a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. The ESAB consumable, which was utilized, appeared to comply with the AWS

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Specification and Classification. The QC inspection and welding performed on this shift appeared to be in general compliance with the contract documents.

Summary of Conversations:

There were general conversations with Quality Control Inspector, Steve Jensen, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

Inspected By:	Daggett,Matt	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
